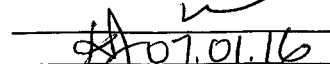
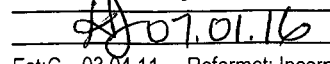


Date: Tuesday, 1/16/2007 11:28:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEM
Job Number : 30274A	
Estimate Number : 10394	
P.O. Number : N/A	Part Number : D29681
This Issue : 1/16/2007 S.O. No. : N/A	Drawing Number : D2968
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : 29964	Material : N/A
Written By : 	Due Date : 1/30/2007 Qty: 40 Um: Each
Checked & Approved By : 	
Comment : Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M4130NR0750	4130 steel rod .750"
-----	-------------	----------------------



Comment: Qty.: 0.4550 f(s)/Unit Total : 18.1986 f(s)
 Material: AISI 4130 Ø 3/4 " Bar
 (M4130N-R0.750) Batch: 103090
 Identify AS D2968-1

ml 07/02/14 40

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 1-Turn Blank as per Folio FA047 and Dwg D2968
 2-Deburr, no sharp edges

ml 07/02/14 40

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07/02/14 40

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio FA047 and Dwg D2968
 2- Deburr

ml 07/02/14 40

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07/02/14 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:28:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 30274A

Part Number: D29681

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

84 07/02/20 (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WB

7/2/20 (40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/22 (40)

Job Completion



U 07-02-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	30274A
Description: Stem		Part Number:	D2968-1
Inspection Dwg: D2968 Rev: B1		Page 1 of 1	

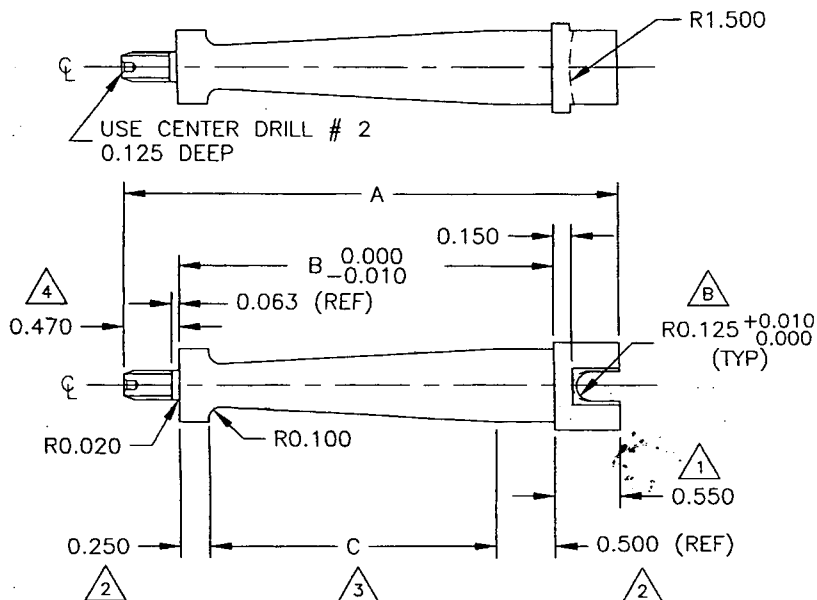
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.040	+/-0.010	5.042	—			
4.020	+0.000/-0.010	4.020	—			
3.270	+/-0.010	3.270	—			
0.470	+/-0.010	0.471	—			
0.250	+/-0.010	0.257	—			
0.550	+/-0.010	0.549	—			
Ø0.750	+/-0.010	Ø0.749	—			
Ø0.625	+/-0.010	Ø0.625	—			
Ø0.363	+/-0.010	Ø0.364	—			
0.250	+0.010/-0.000	0.283	—			
0.625	+/-0.010	0.625	—			
0.150	+/-0.010	0.150	✓			
0.250	+0.010/-0.000					
0.625	+/-0.010	0.625	—			
0.150	+/-0.010					
1/4-28 Major dia	0.243 - 0.249	0.248	—			
MOW	0.261 - 0.267	0.265	—			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07/02/13	Date: 07.02.116	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D2968-041	KJ/RF	
B	05.05.26	Dimensions added	KJ/JLM	<i>[Signature]</i>



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ Ø0.750 O.D.

△ Ø0.625 O.D.

△ MACHINE UNIFORM TAPER FROM Ø0.363 O.D. TO Ø0.625 O.D.

△ 1/4-28 UNF THREAD WITH 0.063 GRIP

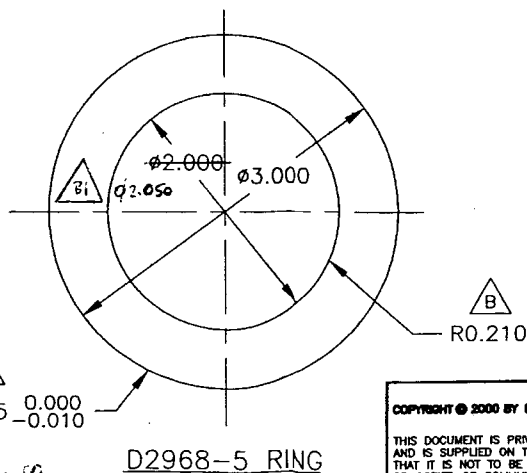
MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS UNLESS OTHERWISE INDICATED

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

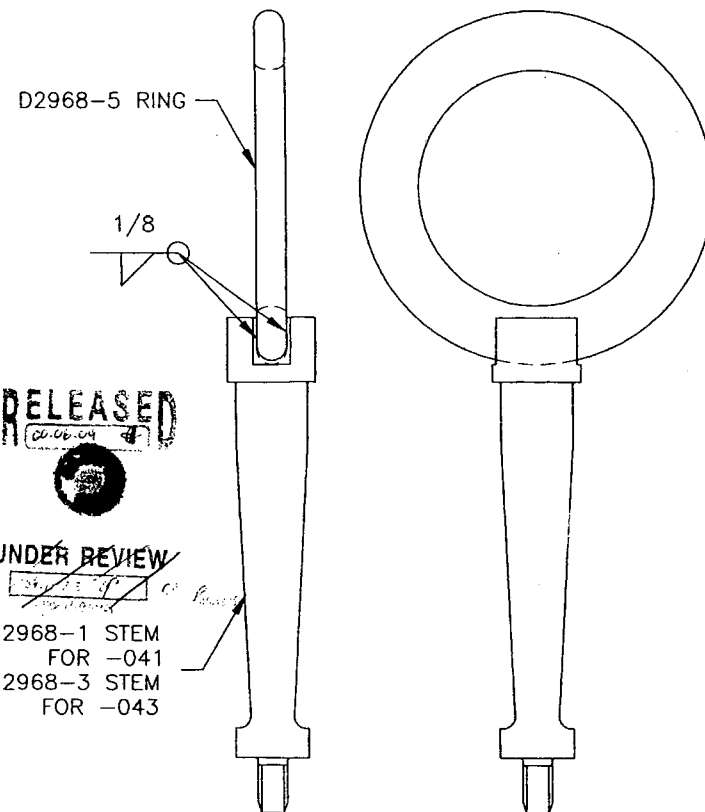
D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968-5 RING



D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING

HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI

FINISH: CAD PLATE ENTIRE ASSEMBLY PER

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED	APPROVED	DRAWING NO. D2968
DATE	00.05.31	TITLE TOW RING

REV. B

SHEET 1 OF 1

SCALE

1:1

WORK ORDER
30274A
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SUBJECT TO AMENDMENT
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ENGINEERING
RETURN TO
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